

Date: Tuesday, 08/04/2008 4:54:15 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Job Number : 38459
Estimate Number : 10262
P.O. Number :
This Issue : 08/04/2008 S.O. No. :
Prsht Rev. : NC Part Number : D350636011
First Issue : / / Type : LANDING GEAR Drawing Number : D2750 REV E
Previous Run : 38458 Drawing Revision : E
Material :
Due Date : 05/05/2008 Qty: 1 Um: Each
Written By :
Checked & Approved By : JD 08.4.09
Comment : Est Rev:I 02.09.25 Rearranged procedure steps KJ
Est Rev:J 06-03-23 As per Rev D JLM
Est Rev:K 06-07.13 As per dsi9343 EC
Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM
Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 003

5 08/05/06 8.4.22 JLD

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B338 463

D H 8-4-23

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch

B33996 BE 08/04/24

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut

8-4-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

as per dwg D2750.

4-Drill pilot holes for Detail G using DT8330

5-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open up holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube***** Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297"

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M106330 DE 08/04/24*

10-Grind welds flush as per Dwg D2750 *SL 8-4-24*

12- Scribe batch# inside per dwg D2750 *M 8-4-23*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS *08/04/24*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *08/04/24*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *08-04-25*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *08/04/25*

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *B38557*

D M 8-4-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number: 38459

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 D34901 CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: *B33824*

RF 08/04/30

11.0 D34903 CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: *B33825*

RF 08/04/30

12.0 D2743 Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: *B22656*

RF 08/04/30

13.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on
sheet 4)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: *M107804*
exp. date: *8-10-1*

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

21
7-4-28

W/O:		WORK ORDER CHANGES						
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Job Number: 38459

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R

Aluminum Rod

batch: *M107263 BE 08/04/30*

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Deburr holes

u
8-4-30

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/01/30 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/30 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M.L

08/05 338459

(1X)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M107550

D350636011
01/05/2008

S.168 07.50

#1 323.3 F

#2 --- F

#3 30mic F

#4 --- F

SP 08-05-01

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

BR 08-05-01

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch: *M 60489*

BR

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

BR 08-05-01

BR 08-05-02

(1)

W/O:		WORK ORDER CHANGES						
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Job Number: 38459

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

21.0 D2745 Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B37303

BR

22.0 D353513 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37584

BR

23.0 D353525 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38162

BR

24.0 D353535 WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38740

BR

25.0 D353613 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38564

BR

26.0 D353625 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38565

BR

27.0 D353635 GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38883

BR

BR 08-05-

W/O:		WORK ORDER CHANGES						
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Job Number: 38459

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

28.0 D35371 WEARPAD



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

WEARPAD

Batch: B36426

BR

29.0 D36311 WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: B38139

BR

30.0 D3488041 BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting LH

Batch: B32232

BR

* 31.0 D3492041 PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B38182

BR

* 32.0 D3492043 PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B38467

BR

33.0 AN3C5A Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: B107737

BR

34.0 AN3C6A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M105300

BR

BR.08-05-02

W/O:		WORK ORDER CHANGES						
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Job Number: 38459

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	AN3C7A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M107376

BR

36.0	AN6C44A	BOLT
------	---------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M107685

BR.

37.0	AN8C35A	BOLT
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M106896

BR.

38.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M107737

BR.

39.0	AN960C816L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M106513

BR

40.0	MS210436	NUT
------	----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M107736

BR

41.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M107756

BR

BR 08-05-02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number: 38459

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M 106516

BR

43.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M 107581

BR

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M 106096

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M 107804

EXP DATE: 08-10

4-Coat all exposed fasteners with "LPS Procyon" batch: M 104251

BR 08-05-02

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/02

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 36343

BR 08/05/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38459

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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48.0	AN8C21A	BOLT
------	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107596

49.0	AN960C816L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107520

50.0	NAS1515H8L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M107581

51.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M107756

52.0	D34931	WASHER
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 38102

53.0	D35321	spacer
------	--------	--------



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: 38101

54.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

Page 9 of 10
08/05/06 (x0)

W/O:		WORK ORDER CHANGES						
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Job Number: 38459

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

Rev F

JS

08/05/06

xl

56.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-06

38459

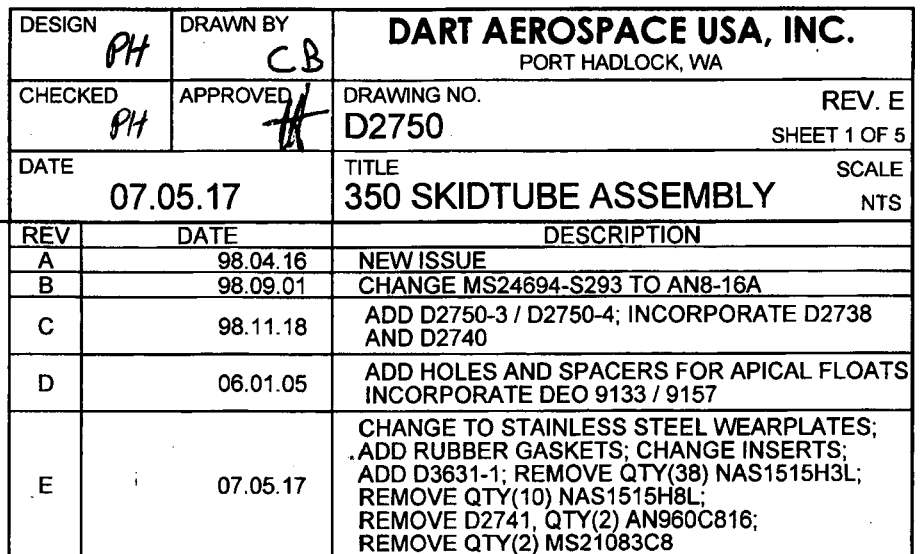
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NOTE: Date & initial all entries



RELEASED
07-08-02

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38459

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DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

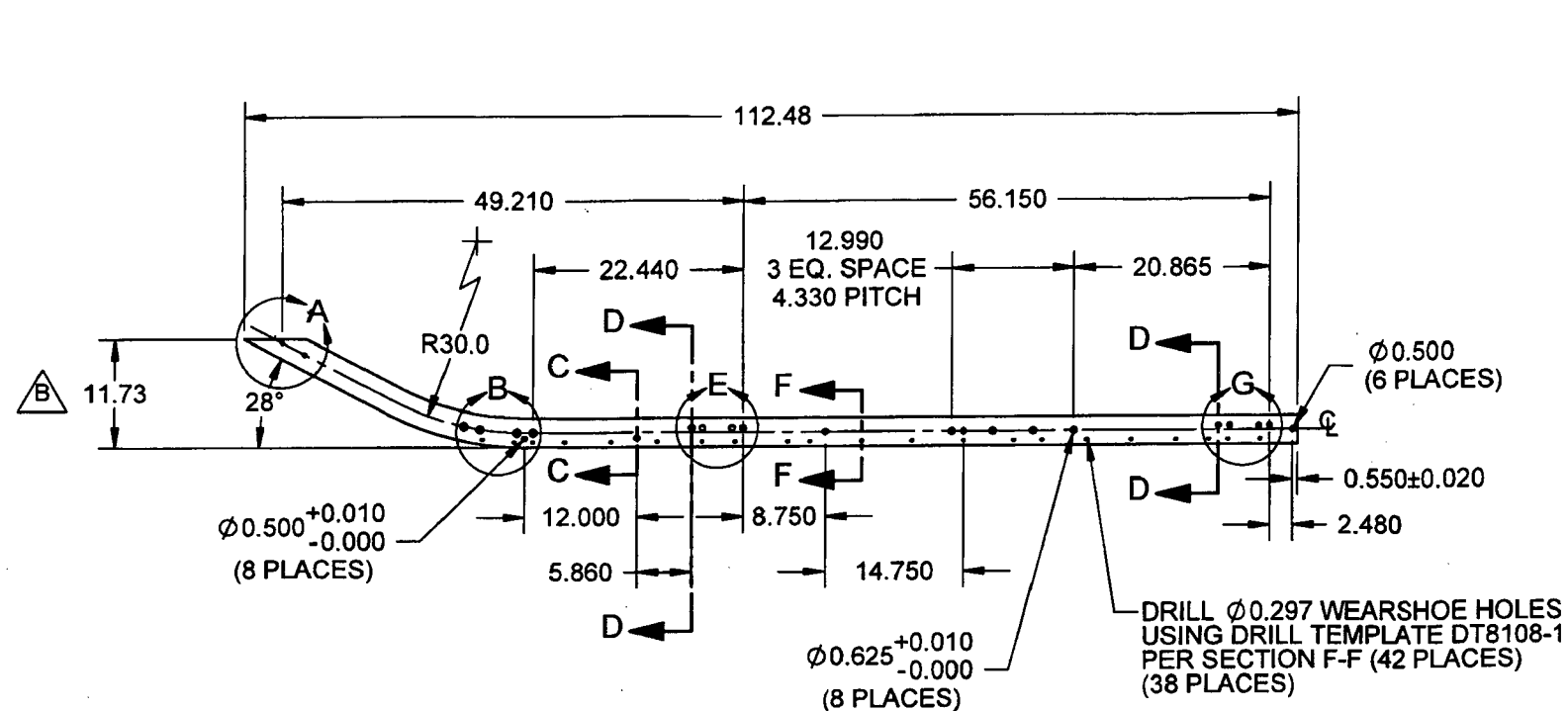
RELEASED
07-08-02

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS POWDER COATING WITH MEK DEGREASER.

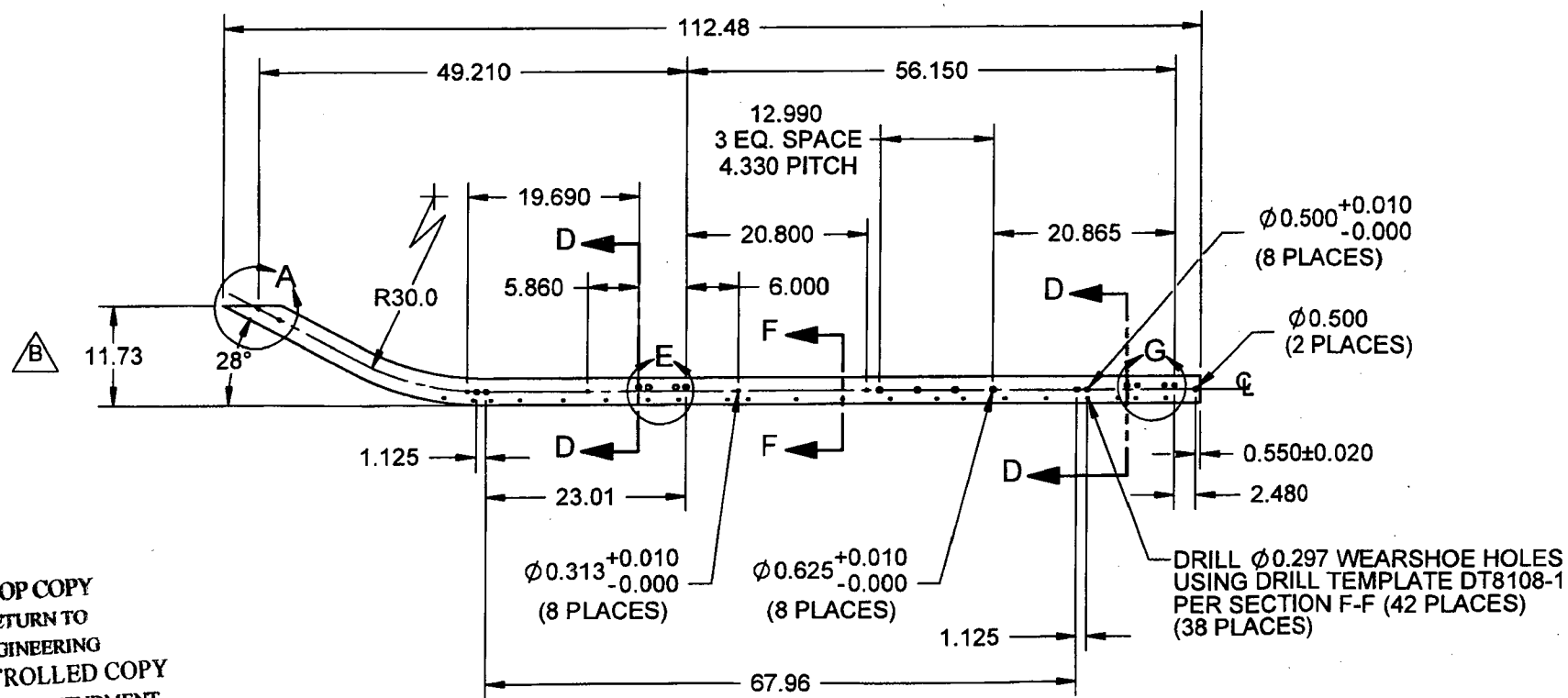
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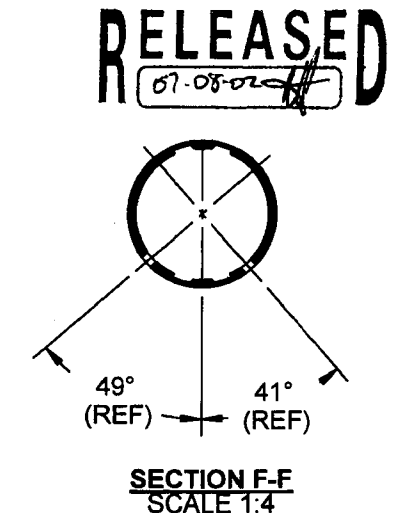
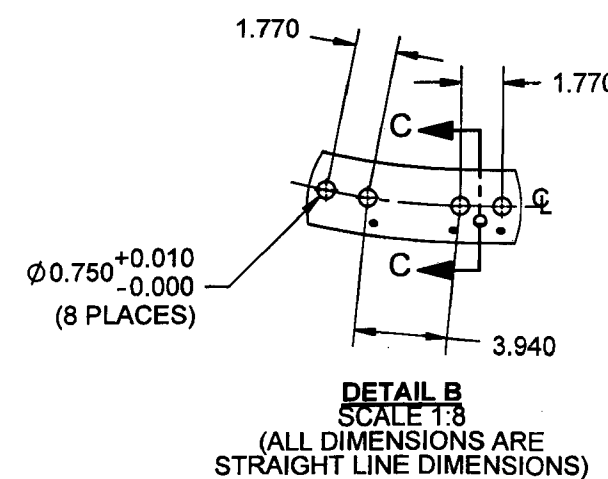
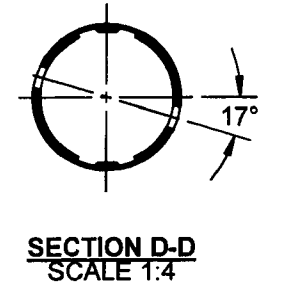
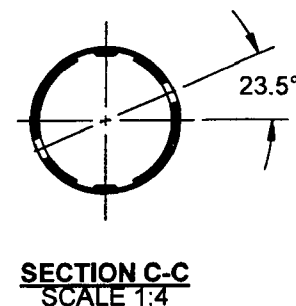
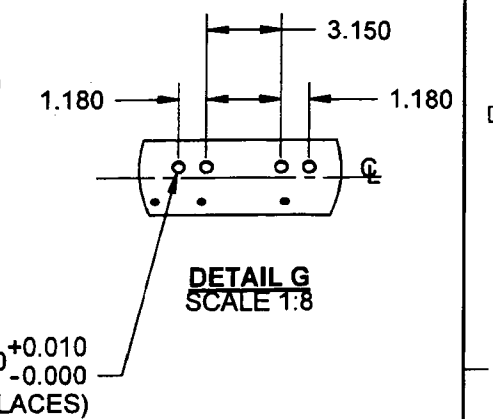
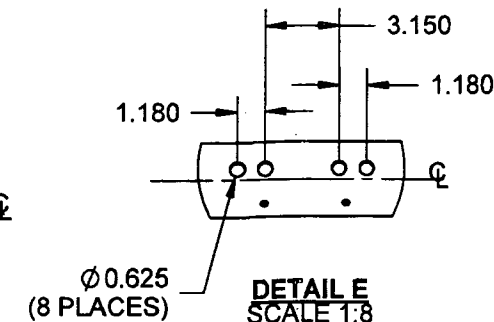
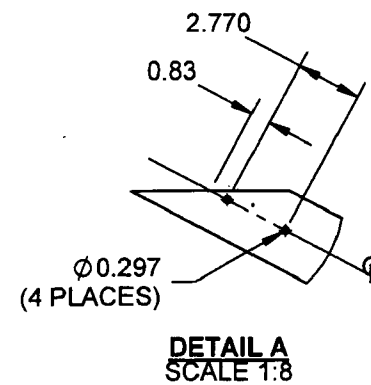
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D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)



D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 3 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20
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INSTALL ALS4-1032-225
INSERTS (4 PLACES)
AFTER FINISH

D2750-1 (LH) OR
D2750-2 (RH)

**D2750-041 ASSEMBLY (SHOWN)
D2750-042 ASSEMBLY (OPPOSITE)**

BLACK ANTI-SKID

BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

2.0
(TYP)

1.78 (REF)
(TO D2739 WEB)

D3488-041
(OR D3488-042)

INSTALL ALS4-1032-225
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

NO INSERT

WELDED SPACER
NOT REQUIRED

D3535-35
D3536-35

AN3C7A BOLT (REF)

RELEASED
07.05.17

D2744 CAP

1/16

DETAIL H
SCALE 1:5

INSTALL:
AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

SECTION J-J
SCALE 1:5

INSTALL AT AFTMOST
D3537-1 WEARPAD:
AN3C7A BOLTS (1)
AN960C10L WASHER (1)
(4 PLACES)

SECTION N-N
SCALE 1:5

INSTALL:
AN3C5A BOLT (1)
AN960C10L WASHER (1)
(38 PLACES)

SECTION M-M
SCALE 1:5

D2743 SPACER (REF)
(TYP)

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D2743 SPACER
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) DRILL OUT SPACER TO $\phi 0.484$
6) SPOT FACE $\phi 0.750$ (SECTION P-P ONLY)

SECTION P-P
SCALE 1:5

SECTION Q-Q
SCALE 1:5

INSTALL:
AN6C44A BOLT (1)
D2745 BUSHING (2)
D3631-1 WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)

SECTION R-R
SCALE 1:5

INSTALL:
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

D3490-3 SPACER

INSTALL:
D3492-043 PLUG
ASSEMBLY
(2 PLACES)

SECTION K-K
(FOR $\phi 0.750$ HOLES ONLY)
SCALE 1:5

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D3490-1 SPACER (4 PLACES) INTO
 $\phi 0.500$ HOLES OR INSERT D3490-3 SPACER
(4 PLACES) INTO $\phi 0.750$ HOLES
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES)
INTO D3490-1 SPACER OR INSERT D3492-043
PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER
ON BOTH ENDS AFTER FINISH

SECTION L-L
(FOR $\phi 0.500$ HOLES ONLY)
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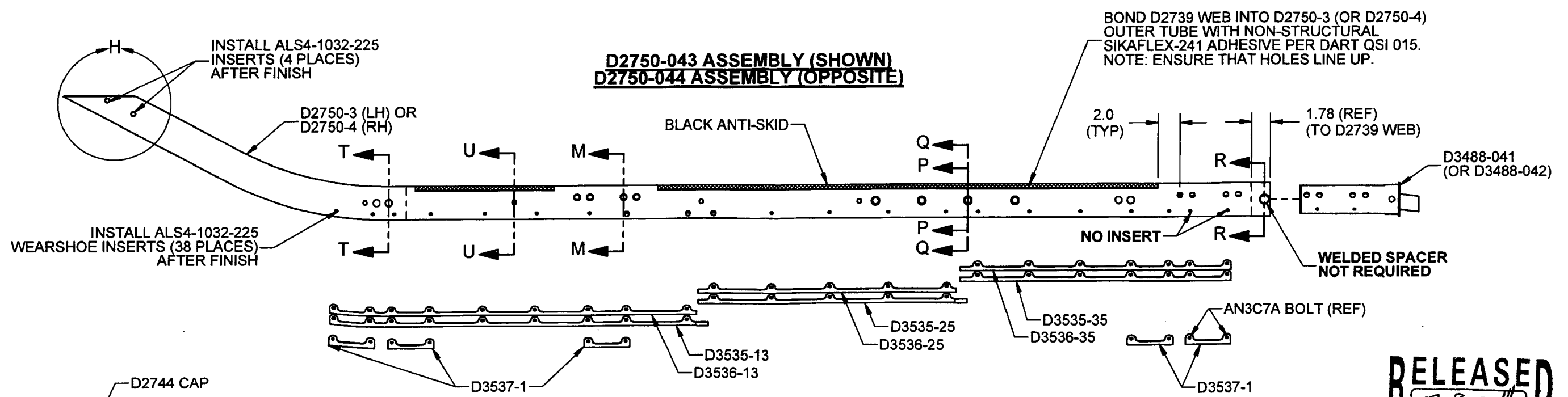
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WORK ON ASSEMBLY

NO. 38/59 (2 PLACES)

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DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10
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8 7 6 5 4 3 2 1



RELEASED
07-08-02

DETAIL H
SCALE 1:5

SECTION J-J
SCALE 1:5

SECTION N-N
SCALE 1:5

SECTION M-M
SCALE 1:5

SECTION Q-Q
SCALE 1:5

SECTION R-R
SCALE 1:5

SECTION T-T
(FOR $\phi 0.500$ HOLES ONLY)
SCALE 1:5

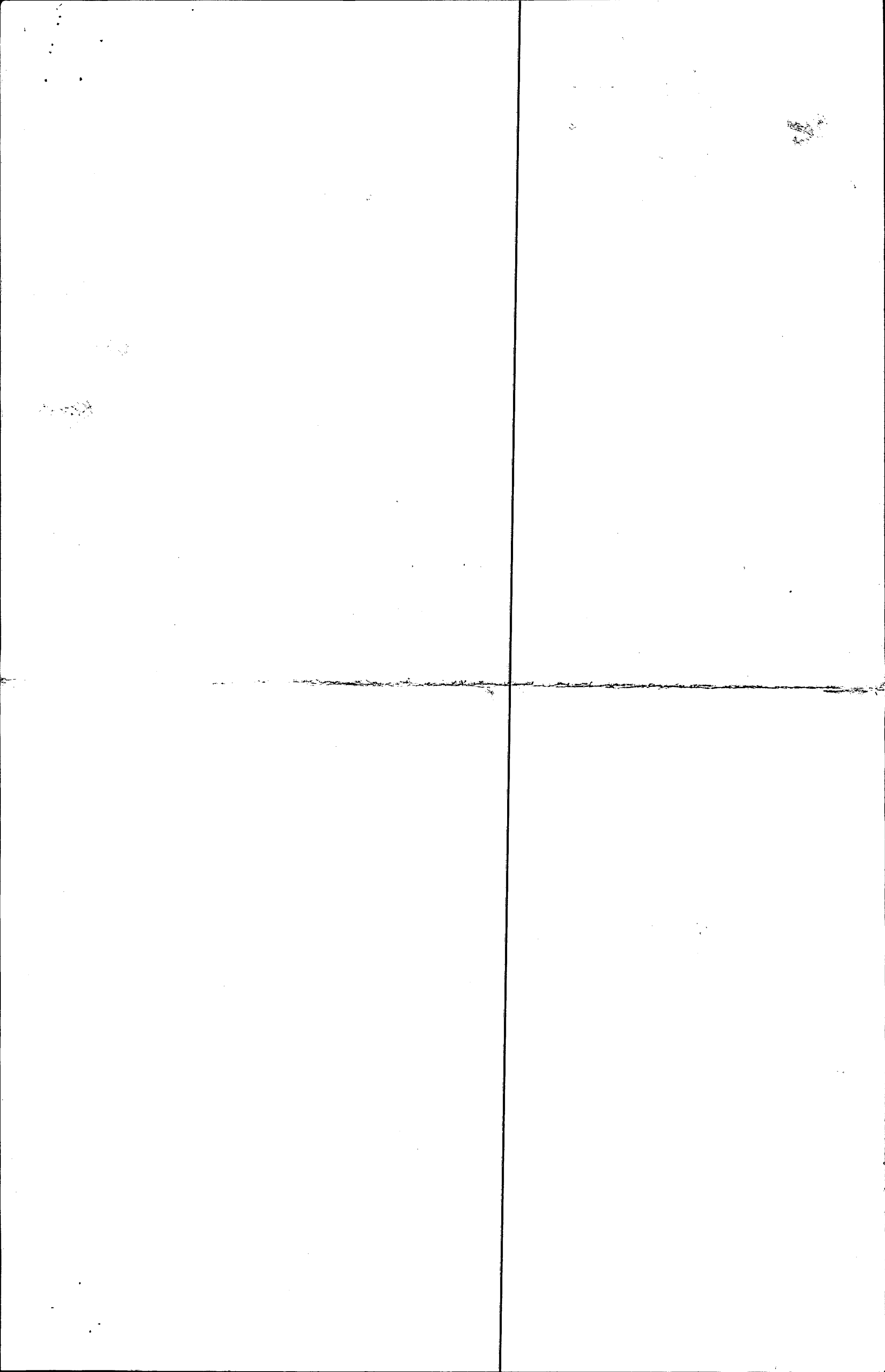
SECTION U-U
(FOR $\phi 0.313$ HOLES ONLY)
SCALE 1:5

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
 - 2) INSERT D3490-5 SPACER (4 PLACES) INTO $\phi 0.313$ HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO $\phi 0.500$ HOLES
 - 3) WELD INTO PLACE
 - 4) GRIND WELD FLUSH
 - 5) INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS AFTER FINISH

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
 - 2) INSERT D2743 SPACER
 - 3) WELD INTO PLACE
 - 4) GRIND WELD FLUSH
 - 5) DRILL OUT SPACER TO $\phi 0.484$
 - 6) SPOT FACE $\phi 0.750$ (SECTION P-P ONLY)

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DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10
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NO. 150

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 37801
Part number: D305 636 041
Description: 30 350 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pct. Dpucl Date of Test Coupon 08-04-23

Welder Barclay Elliot Date of Test Coupon 08-04-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld